Work Orde January-21-13 1		53		*(959	6 3*								Page	1
Revision ID:	D3066-1 Spacer			Accept		*N9	900	<u>040</u>	100)*	Setup	Start Stop		S1* S2*	-
Start Date: Required Date: 2 Reference:		Start Qty: 60.00 Req'd Qty: 60.00	*60* *60*				st Item l stomer:	ID:							
Approvals:		MLJ	Date: <u> 3-01-23</u>					ate:			Run	Start Stop		R1* R2*	
Sequence ID/ Work Center ID		Operation Description		Set U Run	p/ Hours	Т	ool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp.	
Draw Nbr	Revisi	ion Nbr													 ,
D3066	Rev B														
100	F	FLOW WATER JET		0.00				-		60			`	(0AS 05	12.02 80
Waterjet FLOW CNC Waterje	t .	Memo 1-Cut as per Dwg Rev: Prog Rev: 2-Deburr if r	<u>3 </u>	0.00								-	X+ -	`	. , ,
*110 *11 0 *	(QC2- Inspect parts off ma	achine FAI/FAIB	0.00						<u>60</u>				OAS 05	13·B·B
QC Quality Control		Memo		0.00										-9-83	. J W
120	(QC8- Inspect parts - seco	ond check	0.00	5m 133	6				60					
120 QC Quality Control		Memo		0.00	13 2	1				<u> </u>					

										DQA:	Date:	
NCR: Ye	s / No				WORK ORDER NON-	COI	NFOR	MANCE / UP	DATE			
							<u> </u>			QA Closed:	Date:	·
Nork Order:					DISPOSITION		'		AGAINST DE	PARTMENT	'PROCESS	
Part No NCR No					Rework Scrap Use-as-is Work Order Update		!	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	-1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other .
	Τ	ı			1		<u> </u>					
Root Cause	Date	Step	Qty		iption of work order update or Non-conformance	1	Initial nief Eng		tion ription	Sign & Date	Verification	QC Inspector
oc/Data							i					
quip/Tooling							1				 	
perator		ļ									 	Ì
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napproved											<u> </u>	
					F	AUL	T CATE	GORY				
Landing	Gear				General		•			-	_	,
	Bending				Bend	<u> </u>	Grain			Ovalized		Pressure/Forced
	Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorred	it	Weld
	Crushed/0	Crimped.			Burrs		Instruct	ions Incomplete/l	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance		Part Moved		
	Heat Trea	t			Countersink	L	Mislabe	eled		Positioned V		<u>,</u>
	Inspection	n Strip in	Tube		Cut Too Short	L	Misreac	d		Power Loss/	Surge	Other
	Ripples in	Bend			Drill Holes		Offset					
	Torque W	aves in E	xtrusio	n [_	Drawing		Out of C	Calibration				
	Turning Sequence		Finish	Out of Sequence				*				

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio

Work Orde January-21-13				*950	963*						Page 2
Item ID: Revision ID: Item Name: Start Date: Required Date: Reference:	D3066-1 Spacer 1/21/13 2/01/13	Start Qty: 60.00 Req'd Qty: 60.00	*60* *60*	Accept	*N900 Cust Item I Customer:		100		etup Star Stop	' *N	S1* S2*
Approvals:	Process P	lan:	Date:	Tooling: SPC (Y/N):		ate:		R	kun Star Stoj	1/1	R1* R2*
Sequence ID/ Work Center II	D	Operation Description Chemical Conversion Coa	t per QSI005 4.1	Set Up/ Run Hours	Tool ID	Tool#	Plán Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 HandFinish Hand Finishing		Memo ماري	· ***	0.00				60	<u>Her</u>	15°5°	S
140		QC Inspect Part Finish		0.00				10	<i>√</i>		OAS 19 9-89
140 QC Quality Control		Memo		0.00				60	9		13.04.0

150

150 Packaging

Packaging

Identify as per dwg & Stock Location: 1003 0.00

0.00 Memo *** STOCK IN STEP CELL***

60 \$ \$ 13.04.2

									DQA.	Date:	
NCR: Y	res / No				WORK ORDER NON-	CONFOR	MANCE / UP	DATE	QA Closed:	Date:	
					DISPOSITION	<u> </u>		AGAINST DE			
Work Orde	er:				DISPOSITION	_		AGAINST DE	PARTIVICIVI	/PROCE33	
Part N	lo				Rework Scrap Use-as-is	Ther	Skid-tube Machining moforming	Crosstube Small Fab Finishing	4	Water Jet od. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	lo				Work Order Update		Large Fab	Composite]	Supplier	
Root				Descri	ption of work order update	Initial	Act	tion	Sign &	}	
Cause	Date	Step	Qty	(or Non-conformance	Chief En	Desc	ription	Date	Verification	QC Inspector
Doc/Data						-					
Equip/Tooling						,					
Operator										ļ	
Material		İ				1					
Setup						1					
Other						1					
Process						1					
Supplier											
Training						,					
Unapproved		1	i			<u> </u>	<u> </u>		<u> </u>		
						AULT CAT	GORY				
Landin	ng Gear			_	General	<u> </u>			7	_	٦ .
	Bending				Bend	Grain		<u> </u>	Ovalized	_	Pressure/Forced
-	Centre No	ot Concer	ntric to (^{D/S}	BOM/Route	Hardw			Over/Under	<u> </u>	Temperature/Cure
}	Cracks			<u> </u>	Broken/Damaged	-	tion Incomplete		Part Incorre		Weld
}	Crushed/	Crimped.		<u> </u>	Burrs	—	tions Incomplete/	Unclear	Part Lost/M		Wrong Stock Pulled
-	Cuffs			\vdash	Contamination	\vdash	enance	ļ	Part Moved		
-	Heat Trea		- 1	<u> </u>	Countersink	Mislat			Positioned \		٦٠٠
	Inspection		Tube	<u> </u>	Cut Too Short	Misrea			Power Loss,	'Surge	Other
1	Ripples in	Bend		1	Drill Holes	Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 95963 Page 3 January-21-13 10:20:19 AM *N900040100* D3066-1 Accept Item ID: Setup Start **Revision ID:** Stop Item Name: Spacer *60* **Start Qty:** 60.00 **Start Date:** 1/21/13 **Cust Item ID:** Required Date: 2/01/13 Req'd Qty: 60.00 *60* **Customer:** Reference: Run Date: _____ **Tooling:** Process Plan: Approvals: Date: Stop Date: SPC (Y/N): Date: Tool ID Tool # Plan Reject Reject Sequence ID/ Operation Set Up/ Accept Insp. Number Stamp Description Run Hours Qty Qty **Work Center ID** Code 0.00 160 QC21- Final Inspection - Work Order Release

0.00

Memo

160

Quality Control

R13-04-3

			DQA:	Date:	19
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			
			OA Closed:	Date:	

-											QA Closed.	Date.	
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	,
Part N						Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update		nitial	Act	tion	Sign &		
Cause	1	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling		İ											
Operator	Ш	İ											
Material	Ш	İ											
Setup								!					
Other	Ш												·
Process	Ш												
Supplier		ŀ											
Training	H												
Unapproved													
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Landii	ng Gea					General				_	1		1
	⊢–-	nding			- L	Bend	\vdash	Grain		<u> </u>	Ovalized		Pressure/Forced
	$oldsymbol{oldsymbol{ ext{H}}}$		t Concen	itric to (O/S	BOM/Route		Hardwa		<u> </u>	Over/Under	⊢	Temperature/Cure
	_	cks			-	Broken/Damaged	\vdash	•	on Incomplete	 -	Part Incorred	├	Weld
	Cut		rimped.		-	Burrs			ions Incomplete/l	Unclear	Part Lost/Mi	ssing [Wrong Stock Pulled
	 i	is at Treat	_			Countarial	\vdash	Mainte Mislabe		<u> </u>	Part Moved	· lana	
			Strip in	Tubo	 	Countersink Cut Too Short	\vdash	Misread		 -	Positioned V Power Loss/	_	Other
	$oldsymbol{oldsymbol{ o}}$	ples in		iube	-	Drill Holes	\vdash	iviisread Offset		<u></u>	rower Loss/	ourge [Tottiei
	⊢ ⊣ `	•	aves in E	vtrucio	, <u> </u>	Drawing	\vdash		Calibration				
	⊢⊣	-	quence	ALI USIOI	' <u> </u>	Finish	\vdash		Sequence			<u> </u>	
	\vdash	-	rquence ct in Tuh	۵		Folio	-		Dimensions			· · ·	

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID:

95963

Parent Item:

D3066-1

Parent Item Name:

Spacer

Start Date: 1/21/13

Required Date: 2/01/13

Start Qty: 60.00

Required Qty: 60.00

Comments:

IPP: C02.11.01Incorporated D3066-1 IPPKJ/RF IPP Rev:B Now M6061-T6 06-06-23 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080 6061-T6 .080 Sheet		Purchased	No			100	sf	298.0686	0.0945	5.968422	W	13.03.	06
				<u>Location</u>		Loc Oty	<u>Lo</u>	c Code					
			ή.	MAT021		298.068632							
		Q	# 121	1172		0.248632							
		¥)	124'	786 1197	766	39.82							
		-		1200	096	168.8							
				1232	279	89.2							

.

								DQA:	Date:	•
NCR: Y	es / No			WORK ORDER NON	I-CONFOI	RMANCE / U	PDATE	QA Closed:	Date:	
Work Orde	r:			DISPOSITION	1		AGAINST DE	-	/PROCESS	
Part No				Rework Scrap Use-as-is Work Order Update	—	Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite	1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root		Ţ		Description of work order update	Initial		ction	Sign &		
Cause	Date	Step	Qty	or Non-conformance	Chief En	g Des	cription	Date	Verification	QC Inspector
Doc/Data										
Equip/Tooling					Į.					
Operator										
Material					'		•			
Setup		·			1					
Other ·	I	1				}			1	

Landing	Gear	General				_		
	Bending	Bend		Grain		Ovalized	Pres	ssure/Forced
	Centre Not Concentric to O/S	BOM/Route		Hardware	Г	Over/Under tolerance	Tem	perature/Cure
	Cracks	Broken/Damaged		Inspection Incomplete		Part Incorrect	Wel	d
	Crushed/Crimped.	Burrs	-	Instructions Incomplete/Unclear		Part Lost/Missing	Wro	ong Stock Pulled
	Cuffs	Contamination		Maintenance		Part Moved		
	Heat Treat	Countersink		Mislabeled		Positioned Wrong		
	Inspection Strip in Tube	Cut Too Short		Misread		Power Loss/Surge	Oth	er
	Ripples in Bend	Drill Holes		Offset				
	Torque Waves in Extrusion	Drawing		Out of Calibration				
	Turning Sequence	Finish		Out of Sequence				
	Wave/Twist in Tube	Folio		Outside Dimensions				

FAULT CATEGORY

Process
Supplier
Training
Unapproved

DART AEROSPACE LTD	Work Order:	95963
Description: Spacer	Part Number:	D3066-1
Inspection Dwg: D3066 Rev: B	.	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005 -0.000	0.128	/		vern	MM-01
0.708	+/-0.010	0.703	V		vern	11 11
0.354	+/0.010	0.352	/		Ver	// 3
0.354	+/0.010	0.352	/		Herr	"
2.250 (Pitch)	+/-0.005	2.151	V		ver	//
16.450	+/0.010	16.450	/		M.T	MM-02
0.080	+/-0.010	0.078	/		jesn	MM-02 MM-01
		49.				

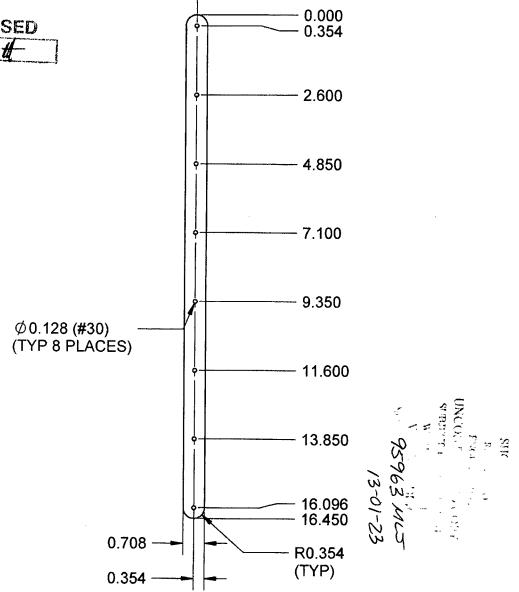
Measured by:	MM		Audited by:	SWJ	Prototype Approval:	N/A
Date:	13.03.0	56	Date:	133フ	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D3065-041	KJ/RF	1
В	06.06.23	Dwg Rev. changed	KJ/JLM X	all.
			TROPOLINE CAN	



DESIGN DRAWN BY DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA APPROVED. CHECKED DRAWING NO. REV. B D3066 SHEET 1 OF 1 DATE TITLE **SCALE** 06.05.29 **SPACER** 1:3 Α 02.09.11 **NEW ISSUE** В 06.05.29 ADD 6061-T6 MATERIAL

RELEASED de de 20 -#



D3066-1 SPACER

1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK

(REF DART SPEC M6061T6S.080)

5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC. M5052H32S.080)
2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1

3) BREAK ALL SHARP EDGES 0.005 TO 0.010

4) PART IS SYMMETRIC ABOUT CENTERLINE

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

6) ALL DIMENSIONS ARE IN INCHES

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